

Date: Thursday, 23/04/2009 3:29:24 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLACARD
Job Number : 47422	
Estimate Number : 11315	
P.O. Number :	Part Number : D33011
This Issue : 23/04/2009 S.O. No. :	Drawing Number : D3301 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 43658	Material :
Written By :	Due Date : 08/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.04.24</u>	
Comment : Est: A04.09.02 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: 8655C209/04/27 (10)

Make as per Dwg D3301Red letters (0.28" min. height) on white adhesive back

Possible Manufacture: From 3M 7 mil masking film # 8522CP or Avery IPM # 2031

Possible Supplier: Studio Lettrage

Material release note is required

2.0	D33011P	PLACARD
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 PLACARD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK809/04/29 (x10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C209/04/28 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:29:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLACARD

Job Number: 47422

Part Number: D33011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/30
JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

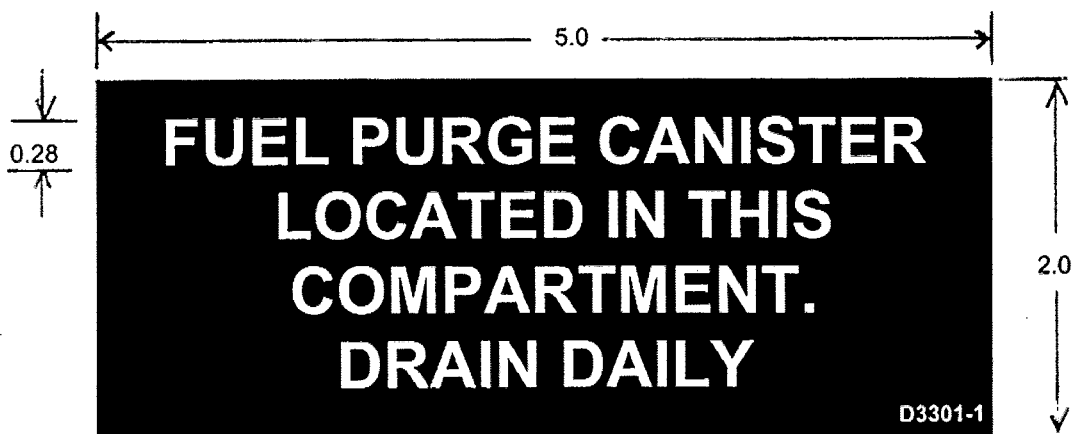
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3301	REV. A SHEET 1 OF 2
DATE 04.07.06		TITLE PLACARD	SCALE 1:1
A	04.07.06	NEW ISSUE	

RELEASED
04.09.04 [Signature]



D3301-1 PLACARD

D3301-1 DECAL

1) MATERIAL:

RED LETTERS ON WHITE ADHESIVE BACK

MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM # 2031

MAXIMUM SIZE IS 5.0" WIDE x 2.0" HIGH

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 47432

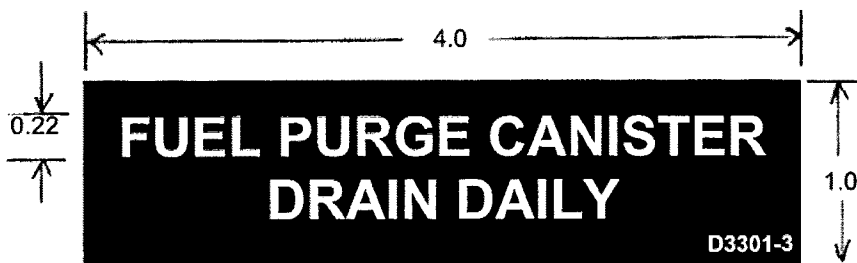
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DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3301	REV. A SHEET 2 OF 2
DATE 04.07.06		TITLE PLACARD	SCALE 1:1

RELEASED
04.04.09 [Signature]



D3301-3 PLACARD

D3301-3 DECAL

1) MATERIAL:

RED LETTERS ON WHITE ADHESIVE BACK

MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM # 2031

MAXIMUM SIZE IS 4.0" WIDE x 1.0" HIGH

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 47422

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210 MAIN W.,
HAWKESBURY, ONT. K6A 2H6
Tel.: 613 632-2001
Fax: 613 632-9491
www.studiolettrage.com

INVOICE / FACTURE

VENDU À:
SOLD TO:

LIVRÉ À:
SHIPPED TO:

No.: 11987
DATE: 04/28/2009
PAGE 1 of 1
Re: Quote No. 6809

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

Dart Aerospace Ltd
Hawkesbury, Ontario

ITEM ARTICLE	QTY QYE	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITÉ	AMOUNT MONTANT
	10		D2269P setup	E		5.00	50.00
	10		D33011P set up	E		5.00	50.00
	10		D33013P set up	E		5.00	50.00
	1		printing	G		50.00	50.00
			E - GST @ 5%				
			G - GST @ 5%; PST @ 8%				
			GST				10.00
			PST Exempt: #6122-5207				
Studio de Lettrage GST: #869034678RP001						TOTAL	210.00

Sold By:

Merci! Thank You!

DART

Purchase Order

Date Apr 27, 2009	Page 1
Purchase Order Number PO00008655	

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED
C8910420

Vendor Address:

Studio de Lettrage 2001
210 Main West
Hawkesbury, ONT K6A 2H6
Canada
Phone (613) 632-5449
Fax (613) 632-9491

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-STU001	Apr 27, 2009	N30	yours	Apr 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Droo-Ship	Unit Cost	UOM	Extended Price
10.0000	D2269P ✓	Placard Comments: AS PER DWG D2269 REV. B1 B47413	30/04/2009	No	3.750000	Each	37.50
10.0000	D33011P ✓	PLACARD Comments: AS PER DWG D3301 REV. A B47422	30/04/2009	No	6.000000	Each	60.00
10.0000	D33013P	PLACARD Comments: AS PER DWG D3301 REV. A B47423	30/04/2009	No	6.000000	Each	60.00

**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY**

Comments:**Tax Summary:**

GST 7.88
GSTME 0.00
GSTND 0.00

Less:

included tax

0.00

Subtotal

157.50

Total tax

7.88

Total purchase order in

CAD Dollars

165.38

Entered By: *CL* CLAVOIE

Approved By: *W*



Scotchcal™

Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlamine can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

Product Bulletin 8522

Release F, Effective January 2003
Black bar in margin indicates a change

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)

- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at www.scotchprint.com

Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

Warranted Durability

Media 8522 with Overlaminate 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

Fabrication

Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

Graphic Construction Options

Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.

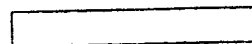
Viewer/Light Source



Overlaminate 8519, 8520
Adhesive on bottom



Imaging Media 8522
Image on top; adhesive on bottom




Opaque Substrate

Note: For the full product names of the 3M products listed on this page, please see page 1.

Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
 - Original packaging, including plastic wrap
 - Relative humidity of 20% to 80%
 - Temperature of 33° to 104°F (0° to 40°C)
 - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

Health and Safety

 **Caution**

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

Warranty and Limited Remedies

3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

The following is made in lieu of all other express or implied warranties, including any implied warranty of **merchantability** or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These

3M

Commercial Graphics Division
3M Center, Building 220-6W-06
PO Box 33220
St. Paul, MN 55133-3220 USA
General Info. 1-800-374-6772
Technical Info. 1-800-328-3908
Fax 1-651-736-4233
Fax-on-Demand 1-800-364-0768 US/Canada or 1-651-732-6506 International
Fax-on-Demand document: 4506
www.scotchprint.com

3M Canada
P.O. Box 5757
London, Ontario
Canada N6A 4T1
1-800-265-1840
Fax 519-452-6245

3M México, S.A. de C.V.
Av. Santa Fe No. 55
Col. Santa Fe, Del. Alvaro Obregón
México, D.F. 01210
52-55-52-70-04-00
Fax 52-55-52-70-22-77

3M Puerto Rico, Inc.
Puerto Rico Industrial Park
P.O. Box 100
Carolina, PR 00986-0100
787-620-3000
Fax 787-750-3035

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at www.scotchprint.com, or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768
International: 1-651-732-6506

Subject	Bulletin No.	FOD No.
Product Bulletins		
3M™ Scotchcal™ Overlamine 8519 and 8520	8519/8520	4524
Instruction Bulletins		
Making thermal ink jet graphics	4.23	6523
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001
Warranties		
Worldwide 3M™ MCS™ Warranty Packet (includes all Commercial Graphics MCS Warranties)		9503
Worldwide 3M™ MCS™ Warranty Overview-Folder		9504

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HP and DesignJet are tradenames of Hewlett Packard.
Sintra is a trademark of Swiss Aluminum Ltd.
Imron is a registered trademark of DuPont in the United States

Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.